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RBE350A94-3700-B
Job Sheet 192194



Part No: RBE350A94-3700-B

Job Qty: 40 pcs

Part Name: Swashplate Immobilizing Tool, Short Brace Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/19/19

Job Tracking No:

Due Date: 4/5/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE350A94-3700-B Rev. 6 IPP Rev. A 18.08.09 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	10 pcs	4/5/19	4/5/19	0.00	1.00	Small Fab - 1		MLO
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	10 pcs	4/5/19	4/5/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
130	Packaging 3-1 - Stock - B4B	10 pcs	4/5/19	4/5/19	0.00	0.00	QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		



Container No: S172681



Part: RBE350A94 - 3700 - B

Job No: 192194

Serial No/Batch: S172681

Revision: 6

Inspector:

Exp Date:

Instructions:

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CANADA
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Date: 04/16/19

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APR 17 2019

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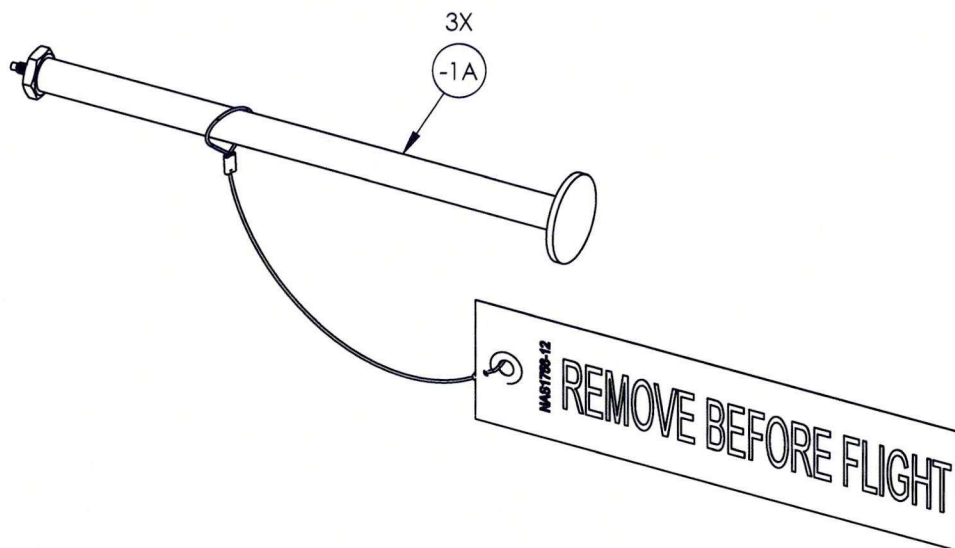
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				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - FG	10 pcs	4/5/19	0.00 0.00	QC 21 - FG - 21	DAS
				QC 21 - FG - 70	APR 18 2019 70
				QC 21 - SA - 53	9-89
Part Op 110 - (Small Fab) 1-Pick bag and tag. Descriptions: 120 - (QC5- Inspect part completeness to step on W/O) 130 - (Identify as per dwg & Stock Location: _____) 140 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
RBE350A94-3700-B-1A	Short Brace Assembly	24 30 pcs (3 ea)	110-Small Fab - 1	23X 5171891	
1X 5167682					
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
110-Small Fab - 1	RBE350A94-3700-B-1A	30	0	0	
Part Specifications					
Specifications could not be found.					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4		BROKE OUT FROM KIT AS INDIVIDUAL TOOL.	8/21/2012	RJC	RW
5		CH'D T/N WAS RBEA94-3700-B IS RBE350A94-3700-B. -01 CH'D DIM WAS Ø.75 IS (Ø.75). WAS .083 IS (.083). -03 CH'D DIM WAS Ø.570 ∇ .079 IS Ø.570. ADDED DIM Ø.586 P.F. -01, (Ø.20). -05 CH'D DIM WAS Ø2.00 IS (Ø2.00), WAS Ø.586 P.F. -05 IS Ø.586 P.F. -01. CH'D TOLERANCE ON NON-CRITICAL PARTS.	5/23/2014	DPD	RJC
6	16-0151	UPDATED TO NEW DRAFTING STANDARD. DELETED P/N B, ADDED P/N'S -1A, -09, -011, -013. CH'D -07 DESCRIPTION WAS SOCKET HEAD SET SCREW DOG POINT IS SOCKET HEAD SET SCREW EXTENDED POINT. -1A ADDED DRAWING. -01, -03, -05 ADDED FINISH SPEC QSMI-6.2.2. B.O. REV D. -01 CH'D DIM WAS (Ø.75) IS Ø.75. WAS (.083) IS .08. ADDED DIMS Ø.6047/.6040 (P.F. -03). Ø.6047/.6040 (P.F. -05). .88. .88, 2X .03 X 45°, ADDED ENGRAVE NOTE. -03 CH'D DIM WAS Ø.586 P.F. -01 IS Ø.6056/.6052 (P.F. -01). -05 CH'D DIM WAS Ø.586 P.F. -01 IS Ø.6056/.6052 (P.F. -01). WAS (Ø2.00) IS 2.00. CH'D MATERIAL WAS 1018 IS 1018/1020 CR.	2/24/2017	RJC	SM



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WITHOUT NOTICE
WORK ORDER
NO. 192194 MW
19-03-15

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1A	3	SHORT BRACE ASSEMBLY			2
	1		-01		TUBE	STEEL		3
	1		-03		CAP	SP HEX		4
	1		-05		FOOT	1018/1020 CR		5
	1	B/O	-07		SOCKET HEAD SET SCREW, EXTENDED POINT	STEEL	M6 X 1 X 30mm (MCMASTER-CARR #92905A225)	2
	1	B/O	-09		REMOVE BEFORE FLIGHT	NYLON	NAS 1756-12	2
	1	B/O	-011		LANYARD CABLE	COATED STEEL	Ø1/16 X 8 (CARR LANE #CL-2-C)	2
	2	B/O	-013		FERRULE	ALUMINUM	Ø1/16 X 3/8 (MCMASTER-CARR #3896T31)	2
	ASSY -1A							

DART AEROSPACE	
TITLE SWASHPLATE IMMOBILIZING TOOL SHORT BRACE ASSEMBLY	
DWG NO. RBE350A94-3700-B	REV 6
MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH	.XX ± .01 ANGLES ± 5°
SPEC	.X ± .1 SURFACES = 125/
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: MACKOVJAK	EUROCOPTER AS350/355
SCALE 1:4	DATE 8/21/2012 SHEET 1 OF 5

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					